

# Work Order ID 53369

November 02, 2009 2:37:10 PM



ASAP

Page 1

Item ID: d3608-1F

Accept



Setup Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 11/2/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: YMF

Date: 09-11-02 Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3608	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608 ☐ Dwg Rev: A ☐ Prog Rev: 1 ☐ 2-  
Deburr if necessary

HB 9-11-2

①

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-11-2

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) S 01/11/03

④

✓

**Work Order ID 53369**

November 02, 2009 2:37:10 PM



Page 2

Item ID: d3608-1F

Accept



Setup Start



Revision ID:

Stop



Item Name: Lower Doubler

Start Date: 11/2/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

09/11/03

09/11/03

MF

09-11-03

# Picklist Print

November 02, 2009 2:37:09 PM

Page 1

Work Order ID: 53369



Parent Item: d3608-1F



Parent Item Name: Lower Doubler



Start Date: 11/2/2009

Required Date: 11/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	124.3128	0.7781 			

11/9-11-0

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

124.3128158

110076

1.37053684

112567

39.7844789

112885

83.1578

111871  
111871  
111871

111871

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53369
<b>Description:</b> Lower Doublor		<b>Part Number:</b>	D3608-1
<b>Inspection Dwg:</b> D3608	<b>Rev:</b> A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	h			
0.500	+/-0.010	.499	b			
1.827	+/-0.010	1.822	b			
8.100	+/-0.010	8.107	b			
11.63	+/-0.030	11.627	x			
0.500	+/-0.010	.499	b			
2.25	+/-0.030	2.249	x			
2.26	+/-0.030	2.275	x			
1.813	+/-0.010	1.807	b			
3.750	+/-0.010	3.750	b			
1.25	+/-0.030	1.252	b			
0.400	+/-0.010	.401	b			
1.350	+/-0.010	1.350	b			
8.90	+/-0.030	8.90	b			
0.345	+/-0.010	.345	b			
1.875	+/-0.010	1.875	b			
0.423	+/-0.010	.425	b			
6.916	+/-0.010	6.919	b			
2.90	+/-0.030	2.915	x			
2.179	+/-0.010	2.180	b			
8.44	+/-0.030	8.430	b			
1.344	+/-0.010	1.342	b			
6.854	+/-0.010	6.851	x			

<b>Measured by:</b>	IB
<b>Date:</b>	9-11-2

<b>Audited by:</b>	S
<b>Date:</b>	09/10/03

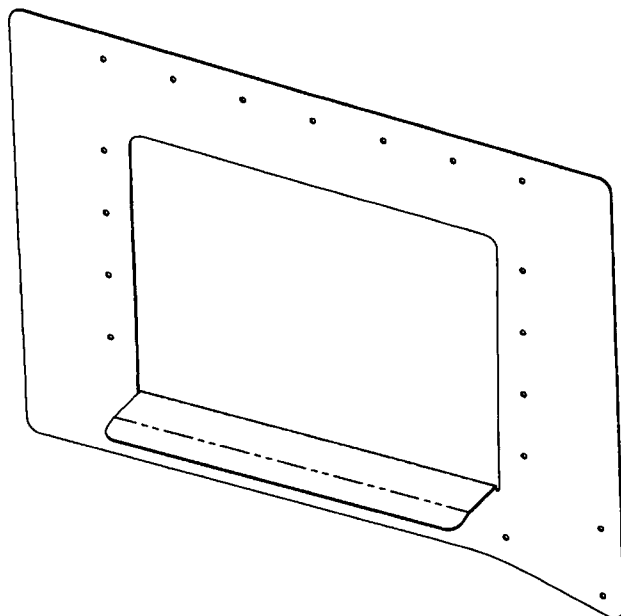
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	

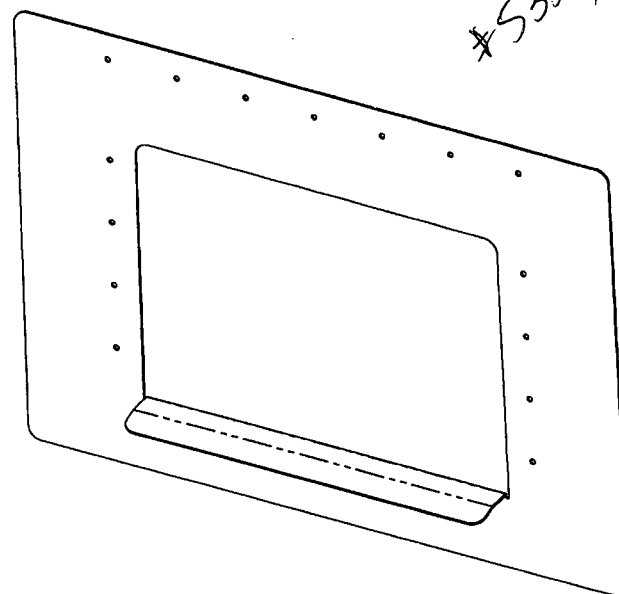
8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



**D3608-1 LOWER DOUBLER**



**D3608-3 UPPER DOUBLER**

**RELEASED**  
08/12/10

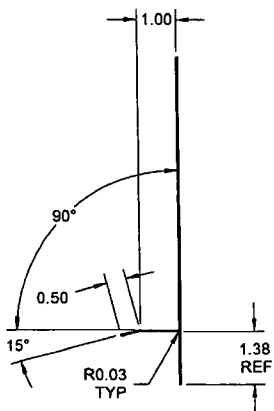
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK  
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs EACH

A		NEW ISSUE				MB	07.04.11
REV.		DESCRIPTION				BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA					
DRAWN							
CHECKED						DRAWING NO.	REV. A
MFG. APPR.						D3608	SHEET 1 OF 4
APPROVED						TITLE	SCALE
DE APPR.		<b>DOUBLER</b>					NTS
DATE	07.04.11		<p align="center">COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</p>				

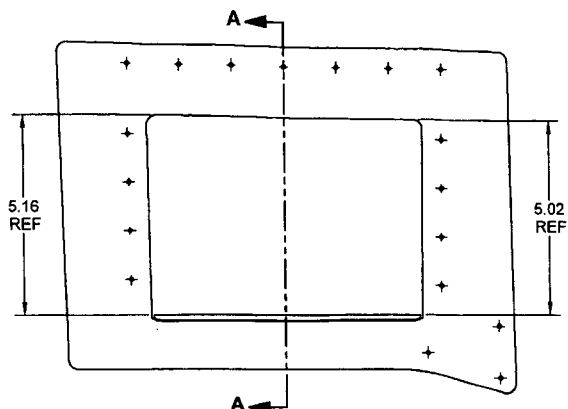
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

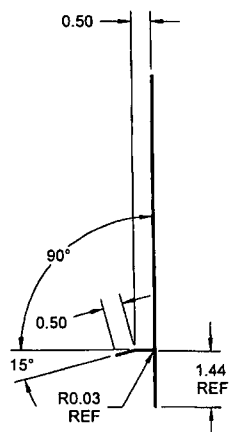


**SECTION A-A**

**D3608-1 LOWER DOUBLER**  
(MAKE FROM D3608-1F)

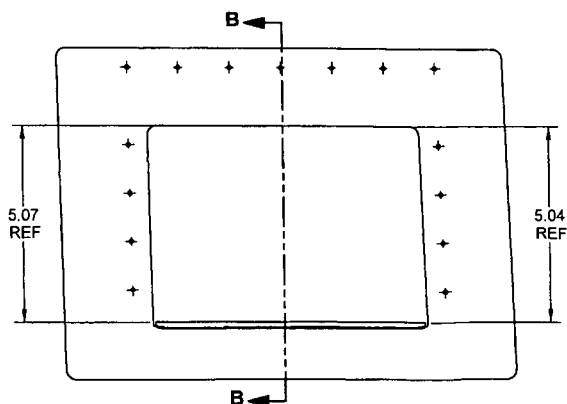


*#53329*



**SECTION B-B**

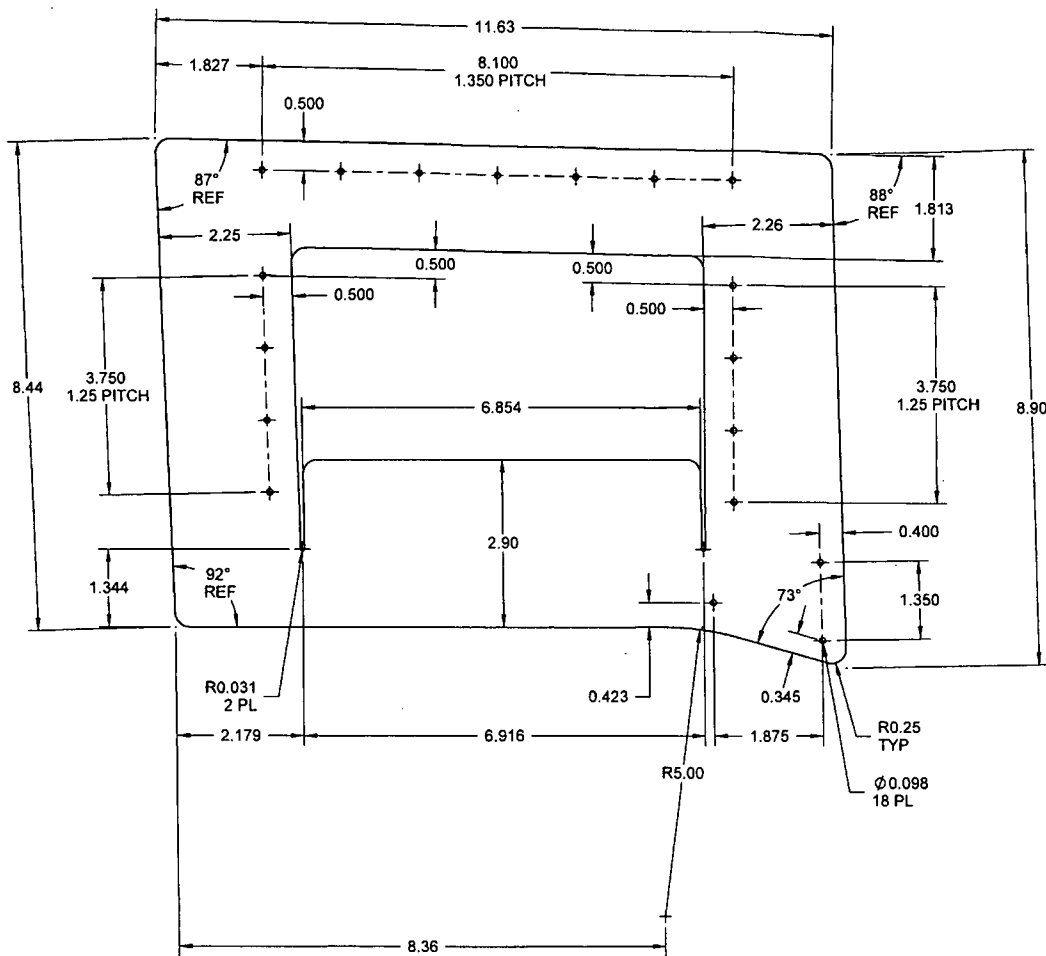
**D3608-3 UPPER DOUBLER**  
(MAKE FROM D3608-3F)



**RELEASED**  
*08/12/10 J/W*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JL</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. <b>D3608</b>	REV. A
MFG. APPR.	<i>DS</i>	TITLE	SHEET 2 OF 4
APPROVED	<i>MD</i>	DOUBLER	SCALE
DE APPR.	<i>HL</i>		NTS
DATE	07.04.11	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

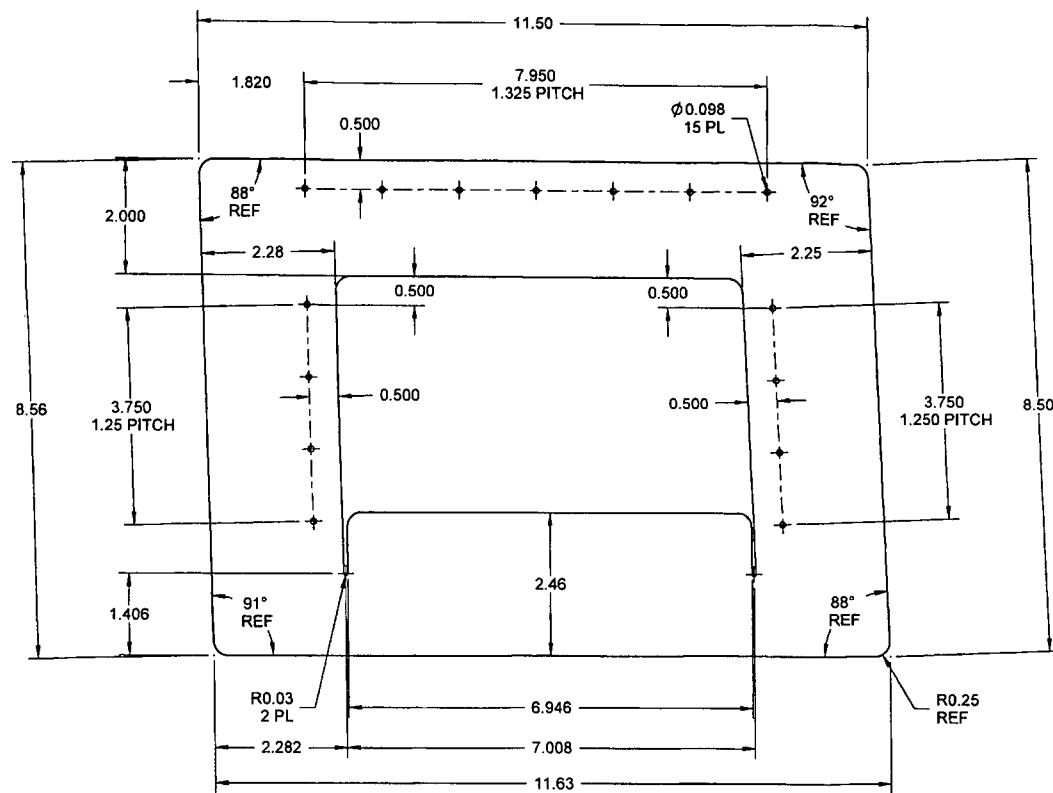
8 7 6 5 4 3 2 1



**D3608-1F LOWER DOUBLER**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3608</b>	REV. A
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLER</b>	NTS
DATE	<b>07.04.11</b>	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
08/12/10 JWW



**D3608-3F UPPER DOUBLER**

# 53369

**RELEASED**  
08/12/10

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3608</b>	REV. A
MFG. APPR.		TITLE	SHEET 4 OF 4
APPROVED		<b>DOUBLER</b>	SCALE
DE APPR.			NTS
DATE	<b>07.04.11</b>	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	